Work Order		<b>2</b> *,		*10	1529	12*							Page 1
Revision ID:	D3236-1 Window		A	Accept	*	<b>1</b> 900	<b>040</b>	100	<b>)</b> * s	Setup	Start Stop	14.	S1* S2*
Start Date: 8 Required Date: 8 Reference:		art Qty: 4.00 q'd Qty: 4.00	*4* *4*			Cust Item I Customer:	D:						·
Approvals:	Process Plan: _	MLJ	Date: 13-08-0\	Tooling:		Da	ate:		I	Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):		Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center ID		eration ecription		Set Up/ Run Hours	rs	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp
Draw Nbr	Revision	Nbr											
D3236	Rev B												
100 *100* Waterjet FLOW CNC Waterjet		OW WATER JET  Memo  Cut as per I	Dwg D3236 Dwg Rev:	0.00 0.00 Prog Rev:	<u>B</u>				4		0_		<u>Ae</u> 13.12
*110 *110*	QC2	2- Inspect parts off n Memo	nachine FAI/FAIB	0.00					<u>4</u>		O		<u>Ae</u> 13·10·0
120 *120* QC Quality Control	QC	8- Inspect parts - sec Memo	ond check	0.00	DAS 27 9-89 112 02	<b>.</b>			4				

												DQA:	Da	ite:	
NCR:	/es	/ No				WORK ORDER NON-O	100	<b>NFORM</b>	MANCE / UP	DATE					
									•			QA Closed:	Da	te:	
Work Orde	ar.					DISPOSITION				AGAINST I	DΕ	PARTMENT	/PROCESS		
WOIK OIG	- ' ' -					Rework	1		Skid-tube	Crosstube		1	Water Jet	Г	Engineering
Part N	No.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.	⊢	Quality
	•					Use-as-is	1		noforming	Finishing		1	re/Packaging	$\overline{}$	Other
NCR I	No.					Work Order Update	]		Large Fab	Composite			Supplier	-	
Root						ption of work order update	1	Initial		tion		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data	Ш								-						
Equip/Tooling	Ш						İ								
Operator							1								
Material			1	1											
Setup															
Other				1											
Process															
Supplier															
Training															
Unapproved															
						F	AUL	T CATE	GORY						·
Landi	ng (	Gear				General		-		-		•		_	-
ļ	L	Bending			L	Bend	L	Grain				Ovalized			Pressure/Forced
		Centre N	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
	L	Cracks				Broken/Damaged		Inspecti	ion Incomplete			Part Incorre	ct		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	'Unclear [		Part Lost/Mi	issing		Wrong Stock Pulled
		Cuffs			Γ	Contamination		Mainte	enance	ſ		Part Moved			_
		Heat Trea	at			Countersink		Mislabe	eled			Positioned V	Vrong		
					<del>- </del>				Other						

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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Work Orde				*105	5292*						Page 2	
Item ID: Revision ID:	D3236-1			Accept	*N900	<b>040</b>	100	<b>)</b> * s	etup Stai	I Z	S1*	
Item Name:	Window								Sto	<sup>p</sup> *N	S2*	
Start Date: Required Date:	8/09/13 8/09/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:					* :	:
Reference: Approvals:	Process P	lan:	Date:	Tooling:	De	ate:	_	R	tun Sta	rt *N	R1*	
Approvais.						ate:			Sto	n	R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS
*130*		Small Fab		0.00				E 4			13/2/	36
Small Fab		Memo		0.00				W IX			Jugo	)
Small Fab		DeburrEngr	ave Part Number & Batc	h Number as per Dwg D32 DAS 27 9-89	236							
*140 *1 <b>4</b> 0*		QC5- Inspect part comp	leteness to step on W/O	0.00	ka			4				:
QC Quality Control	•	Memo		0.00					The state of the s			
- 150		Identify as per dwg & St	tock Location	IF 0.00				. 1.5			10	: :
*150* Packaging Packaging		Memo		0.00				_4X_		- 13	5-12-	<b>3</b>

DAS 26 9-89

										DQA:	Dat	e:
NCR:	res /	No			WORK ORDER NON	1-CO	NFOR	MANCE / UPDATE		QA Closed:	Dat	۵٠
								<del></del>				C.
Work Orde	er:				DISPOSITION			AGAII	NST DE	PARTMENT,	/PROCESS	
					Rework			Skid-tube Crosst	ube	]	Water Jet	Engineering
Part N	۷o				Scrap		1	Machining Small	Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming Finish	ning	Rec/Stor	re/Packaging[	Other
NCR I	No				Work Order Update			Large Fab Compo	site		Supplier	
						<del></del>						
Root					scription of work order update		Initial	Action		Sign &		
Cause	Di	te Ste	ep Q	ty	or Non-conformance	CI	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data	Ш											ł
Equip/Tooling				l								
Operator	Ш											
Material	Ш											
Setup	Ш											
Other												
Process												
Supplier	Ш	ł									:	•
Training	Ш									İ		
Unapproved												
						FAU	LT CATE	GORY				
Landi	ng Gear				General		_			_	_	
	Ben	ding			Bend		Grain			Ovalized		Pressure/Forced
	Cent	re Not Co	ncentric	to O/S	BOM/Route	L	Hardwa	re	L	Over/Under	tolerance	Temperature/Cure
	Crac	ks			Broken/Damaged		Inspect	on Incomplete		Part Incorred	ct [	Weld
	Crus	hed/Crimp	oed		Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing [	Wrong Stock Pulled
	Cuff	S			Contamination		Mainte	nance		Part Moved		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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Work Ord				*105			Page 3				
Item ID: Revision ID: Item Name:	D3236-1 Window			Accept	*N900	<b>040</b>	100	)* 5	Setup Star	173	S1* S2*
Start Date: Required Date Reference:	8/09/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:				IN	
Approvals:	Process QC:	Plan:	Date:	Tooling: SPC (Y/N):		ate:		]	Run Star Sto	n '' [ <b>\]</b>	R1* R2*
Sequence ID/ Work Center 1 160 *160* QC Quality Control	ID	Operation Description QC21- Final Inspection Memo	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

pl 13-12-4

											DQA:	Date:	
NCR: Y	Yes	/ No				WORK ORDER NON-C	ON	<b>IFOR</b>	MANCE / UPI	DATE			
											QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	-					Rework Scrap			Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality Other
NCR N	No					Use-as-is Work Order Update		mem	noforming Large Fab	Finishing Composite	Rec/Stol	Supplier	Other
Root					Descri	ption of work order update	l	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling											1		
Operator													
Material													l
Setup	П				:								i
Other													:
Process	П												
Supplier	П											!	
Training					ļ								
Unapproved													
	•				•	Ę	AUL	T CATE	GORY				
Landi	ng G	iear				General							
	$\Box$	Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s $\Box$	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

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Page 1

Work Order ID:

105292

Parent Item:

D3236-1

Parent Item Name:

Window

**Start Date: 8/09/13** 

Required Date: 8/09/13

Start Qty: 4.00

Required Qty: 4.00

Comments:	IPP rev. A 06.03.07	New Issue	EC										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No			110	sf	661.8445	1.955	8.2315788	Ae	13:1	2.01

Location	Loc Qty	Loc Code	
MAT	211		
m125767	211		125767-> 4.1
MAT019	171.1		
123704	33		
123949	68.5		
124559	69.6		124559 - 54
ther	279.7445		
123895	279.7445		

			,	•	,	
DQA:_	Da	ate:				

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

	<u>,                                     </u>							•		QA Closed:	Date	e:
Work Ordei	<del>.</del> .				DISPOSITION			•	AGAINST DE	PARTMENT	PROCESS	
Part No					Rework Scrap Use-as-is		r	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	o				Work Order Update	]		Large Fab	Composite	Rec/Stor	Supplier	Other
Root				Descri	ption of work order update	In	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Ooc/Data equip/Tooling Operator Material detup Other Process Supplier												
Training Unapproved	_											
Jiiapproved 1		L	L		<b>F</b> .	AUL1	CATE	GORY				
Landin	g Gear				General							
-	Bending Centre N Cracks Crushed/ Cuffs Heat Tre Inspection Ripples in	'Crimped at on Strip in on Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misreac Offset	on Incomplete ions Incomplete/ nance iled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
ŀ	Turning			''	Finish	$\boldsymbol{\vdash}$		Sequence				
	Wave/Tv			<u> </u>	Folio	$\vdash$		Dimensions				

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DART AEROSPACE LTD	Work Order:	105292
Description: Window	Part Number:	D3236-1
Inspection Dwg: D3236 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Artic	е 🔲	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.84	+/-0.030	11.84			T	JKM-06
23.03	+/-0.030	11.84	_		T	
					-	
					***	
	,					
-						
					*******	
					-	

		DAS		
Measured by:	Audited by:	27	Prototype Approval:	N/A
Date: 13 111-30	Date:	12 12 W	Date:	N/A

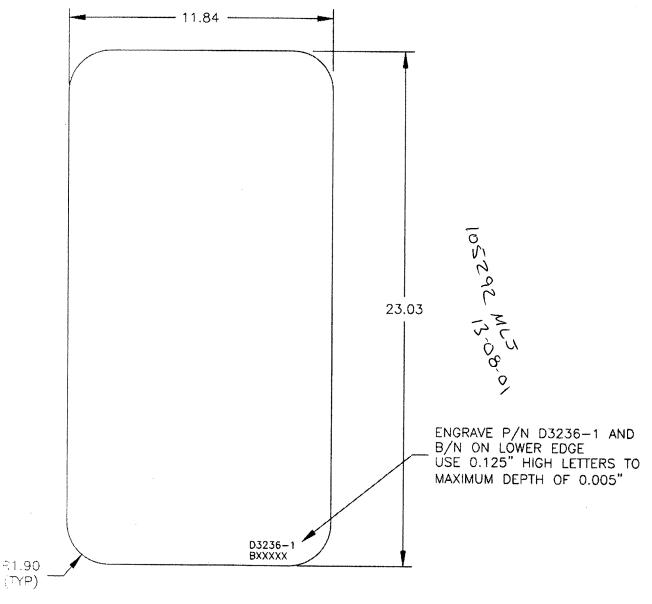
Rev	Date	Change		Revised by	Approyéd
Α	04.06.25	New Issue	P/O D412-709-015/-017	KJ/JLM 🖟	9/1
					<del></del>





DESIG	#	DRAWN BX	DART AERO HAWKESBURY, OI			
CHECH	ED W	APPROVED -	DRAWING NO. D3236	SHEET	REV.	
DATE		•	TITLE	······································	SCA	LE
 04.0	5.05		WINDOW		N.	T\$
Α		03.12.18	NEW ISSUE			

Α	03.12.18	NEW	ISSUE		
В	04.05.05		THICKNESS	ENGRAVING	SPEC



<u>D3236-1 WINDOW</u>

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 0.125" THICK (REF DART SPEC. M-ACRYLIC-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

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